

Work Order ID 162242

Tuesday, May 30, 2017 11:50:54 AM

162242

Page 1

Item ID: D206-642-341BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 7/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DAS**21****9-82**

Date: MAY 30 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

F(DEO)

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-341 CHG005

N/A 20

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Item ID: D206-642-341BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop ***NS2***

Start Date: 7/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00				1	X	17	06-14
110									
Skidtubes	Memo	0.79							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.								
	A/R Aluminum Rod MB6158/MB6920								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297"								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650								
	11- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)								
	12-Deburr								

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Item ID: D206-642-341BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop ***NS2***

Start Date: 7/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.02

Quality Control

① 17-06-21

DAS
9
9-89

116

QC9- Inspect visual per QSI004- Fusion Welds

0.00

116

QC

Memo

0.00

Quality Control

① 17-06-24

DAS
9
9-89

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.50

Hand Finishing

(x1) Ø

2017/06/21

BEB

Work Order ID 162242

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Page 4

Item ID: D206-642-341BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID:
 Item Name: Replacement Skidtube (Fits LH or RH) Stop ***NS2***
 Start Date: 7/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/18/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-00
125 *125* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.01				1	0	17-06-21		
130 *130* Skidtubes	Skidtubes Memo 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: 17-06-21 Time: 14.25 Finish Date: _____ Time: _____ A/RSikaflex-291 M137526 Sikaflex expiry date: 18-04-21	0.00 0.36				1	0	2017/06/21		
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1	0	17-06-22		

2017/06/21
 (ND)
 2017/06/21
 17-06-22

DAS
18
9-00

Work Order ID 162242

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Item ID: D206-642-341BL

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop ***NS2***

Start Date: 7/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

Skidtubes

Skidtubes

Memo

1.31

1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

1 17-06-23
DAS
38
9-88
JUN 23 2017

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.02

Quality Control

1
DAS
38
9-88
JUN 23 2017

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.36

Hand Finishing

1 MGG 17/06/28

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Item ID: D206-642-341BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop

NS2

Start Date: 7/6/2017

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/18/2017

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

~~*200*~~

SprayPaint

Spray Painting

205

Spray Painting per QSI005 4.2

Issue PO

0.00

0.63

36936

DAS 13 9-89

Memo

MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484

207/07/05

DAS 21 9-89

Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

SPRAY PAINT BLUE BATCH:

AS PER QSI

DEL FLEET CLEAR B

210

210

QC

Quality Control

QC14- Inspect Spray Paint

0.00

QC6 PD

Memo

0.01

17.07.24

DAS 9 9-89

Packaging Receive & inspect 1x SP 17-7-11

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Item ID: D206-642-341BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube (Fits LH or RH)

Stop

NS2

Start Date: 7/6/2017

Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/18/2017

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Assemble as per dwg
HandFinishing

0.00

220

HandFinish

Hand Finishing

Memo

1.20

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside
insert holes before installing wearpad/wearplate.

A/RSikaflex-291

Sikaflex expiry date:

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install
plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive
A/RSikaflex-291

Sikaflex expiry date:

6- Install D2680-041 Nut Plate as per Dwg D2650

7-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch:

12 6 all 6/07/25120598 M137742 18/05M13659517/07M137947

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Item ID: D206-642-341BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube.(Fits LH.or-RH)

Stop

NS2

Start Date: 7/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.01

Quality Control

DAS
38
9-89

JUL 26 2017

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.02

Quality Control

DAS
38
9-89

JUL 26 2017

250

Identify as per dwg & Stock Location:

0.00

250

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341
Location:FG083DAS
27
9-89

AUG 08 2017

— PPP 163628

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Item ID: D206-642-341BL

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement.Skidtube (Fits LH or RH)

Stop *NS2*

Start Date: 7/6/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.10

Quality Control

 AUG 08 2017
AUG 08 2017

Picklist Print

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Page 1

Work Order ID: 162242

162242

Parent Item: D206-642-341BL

*D206-642-341RI *

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 7/6/2017

Required Date: 7/18/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD verf: JLM IPP Rev: M 14.04.25 ECN14-520 DD verf: JLM IPP REV: N 15.10.09 ADDED BL DD VERF: JLM IPP REV: O 16.01.22 PAR16-484 DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No			110	Each	7.0000	1	1			
D2620									**			17-06-12	
Skidtube, 206 Skidtube												D-7.	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002	161573	7				1			
					159934	7							
D2647		Manufactured	No			110	Each	28.0000	1	1			
D2647									**			BE 170612	
Cap													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001	159737	28							
					161515	7							
						21				1			
D2654-5		Manufactured	No			130	Each	12.0000	1	1			
D2654-5									**				
Web													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002	159391	12							
					161577	12							

① 2017/06/21
 AP [Signature]

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Work Order ID: 162242

162242

Parent Item: D206-642-341BL

***D206-642-341RI ***

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 7/6/2017

Required Date: 7/18/2017

Start Qty: 1.00

Required Qty: 1.00

D4720-1 Manufactured No

150 Each 245.0000 19 19

D4720-1

Spacer

**

17-06-22

Location

Loc Qty

Loc Code

LG001

161317

245

4

146840

241

160468

19

27

ALS4-1032-130 AELS4-1032-130 Purchased No

220 Each 3,276.000 54 54

AI S4-1032-130

Rivnut

**

all 11/07/21

Location

Loc Qty

Loc Code

FG

50

FG

M135442

50

FP001

2911

M133077

3

M136579

2908

st555

315

M136579

315

X5V

CCR264SS3-3 CCR264SS3-3-03 Purchased No

220 Each 400.0000 2 2

CCR264SS3-3

Cherry Rivet

**

all 12/01/21

Location

Loc Qty

Loc Code

ST321

400

m137622

400

X2

Picklist Print

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Work Order ID: 162242

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Parent Item: D206-642-341BL

***D206-642-341RI ***

Parent Item Name: Replacement Skidtube (Fits LH.or.RH)

Start Date: 7/6/2017

Required Date: 7/18/2017

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

220

Each

113.0000

2

2

CR3212-4-03

**

Cherry Rivet

LocationLoc QtyLoc Code

CCK003

100

1136741

x2

m137321

100

FP001

13

m134943

13

D2646BL

Manufactured

No

220

Each

4.0000

1

1

***D2646RI ***

**

Aft Cap

LocationLoc QtyLoc Code

FP001

1

B162284

x1

141196

1

FP002

3

159697

3

D2651-1BL

Manufactured

No

220

Each

207.0000

14

14

***D2651-1RI ***

**

Plug

LocationLoc QtyLoc Code

FP001

207

B161516

x14

139869

26

141821

13

159295

168

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Shop Packet Print

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Work Order ID: 162242

162242

Parent Item: D206-642-341BL

***D206-642-341RI ***

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 7/6/2017

Required Date: 7/18/2017

Start Qty: 1.00

Required Qty: 1.00

D2651-3 Manufactured No

220 Each 1,001.000 14 14

D2651-3

O-Ring

**

all 13/6/24

Location

Loc Qty

Loc Code

FP001

1001

147815

1

159709

250

161447

250

161517

500

x1

D2680-041 Manufactured No

220 Each 58.0000 1 1

D2680-041

Nut Plate

**

all 12/10/24

Location

Loc Qty

Loc Code

LG001

58

141543

8

150657

1

158428

49

B161578

x1

D3537-1 Manufactured No

220 Each 232.0000 6 6

D3537-1

Wearpad

**

all 10/10/24

Location

Loc Qty

Loc Code

FG

11

79833

1

88562

10

FP001

221

141922

7

147593

5

154226

1

159353

52

159355

2

159356

54

161530

50

161531

50

B162601

x4

*

x2

*

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Work Order ID: 162242

162242

Parent Item: D206-642-341BL

*D206-642-341RI *

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 7/6/2017

Required Date: 7/18/2017

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

220

Each

49.0000

1

1

D3537-3

Wearpad

**

all 12/07/20

Location

Loc Qty

Loc Code

FG

8

86237

8

FP001

41

159351

31

161532

10

D4956-11

Manufactured No

220

Each

6.0000

1

1

D4956-11

Wearplate Fwd

**

all 12/07/20

Location

Loc Qty

Loc Code

FP002

6

159169

6

B161534

D4956-23

Manufactured No

220

Each

16.0000

1

1

D4956-23

Wearplate Center Fwd

**

all 12/07/20

Location

Loc Qty

Loc Code

FP002

16

159364

16

B161571

D4956-35

Manufactured No

220

Each

17.0000

1

1

D4956-35

Wearplate Aft

**

all 12/07/20

Location

Loc Qty

Loc Code

FP002

17

159406

17

B161570

all

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Work Order ID: 162242

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Parent Item: D206-642-341BL

*D206-642-341RI *

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: -7/6/2017

Required Date: -7/18/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

220

Each

231.0000

2

2

MS27039-1-08

**

Screw

Location

Loc Qty

Loc Code

FP001

91

m136047

3

m137361

88

GA

22

m128636

22

ST281

118

m137361

118

MS27039-4-06

Purchased

No

220

Each

59.0000

1

1

MS27039-4-06

**

Screw

Location

Loc Qty

Loc Code

FP001

54

m132317

5

m137320

49

ST279

5

m126534

5

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Parent Item: D206-642-341BL

*D206-642-341RI *

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 7/6/2017

Required Date: 7/18/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

220

Each

1,336.000

54

54

MS27039C1-08

**

SCREW

12/07/20

Location

Loc Qty

Loc Code

FP001

242

M138040

x54

m135127

3

m135744

51

m135979

1

m136295

3

m137333

184

over006

1000

m 137459

1000

ST277

94

m127255

94

NAS1149C0332R

Purchased

No

220

Each

4,561.000

54

54

NAS1149C0332R

**

WASHER

12/07/20

Location

Loc Qty

Loc Code

FP001

1818

M137951

x26

m137381

1818

GA

514

m133284

22

m136444

492

ST260a

2200

m135408

0

m135908

200

m136741

0

m137597

2000

x26

ST266

29

m136741

29

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Parent Item: D206-642-341BL

***D206-642-341RI ***

Parent Item Name: Replacement Skidtube (Fits LH or RH)

Start Date: 7/6/2017

Required Date: 7/18/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

220

Each

1,163.000

2

2

NAS1149D0332.J

**

Washer

all 12/07/20

Location

Loc Qty

Loc Code

FP

225

m136015

8

m137075

217

X 2

GA

308

m136643

308

ST264

630

m136015

0

m137412

630

NAS1149D0463J

Purchased

No

220

Each

3,163.000

1

1

NAS1149D0463.J

**

Washer

all 12/07/20

Location

Loc Qty

Loc Code

GA

40

M135056

40

ST260a

2000

M137371

2000

ST263

1123

M137381

123

M137544

1000

*M136983 * x 1*

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

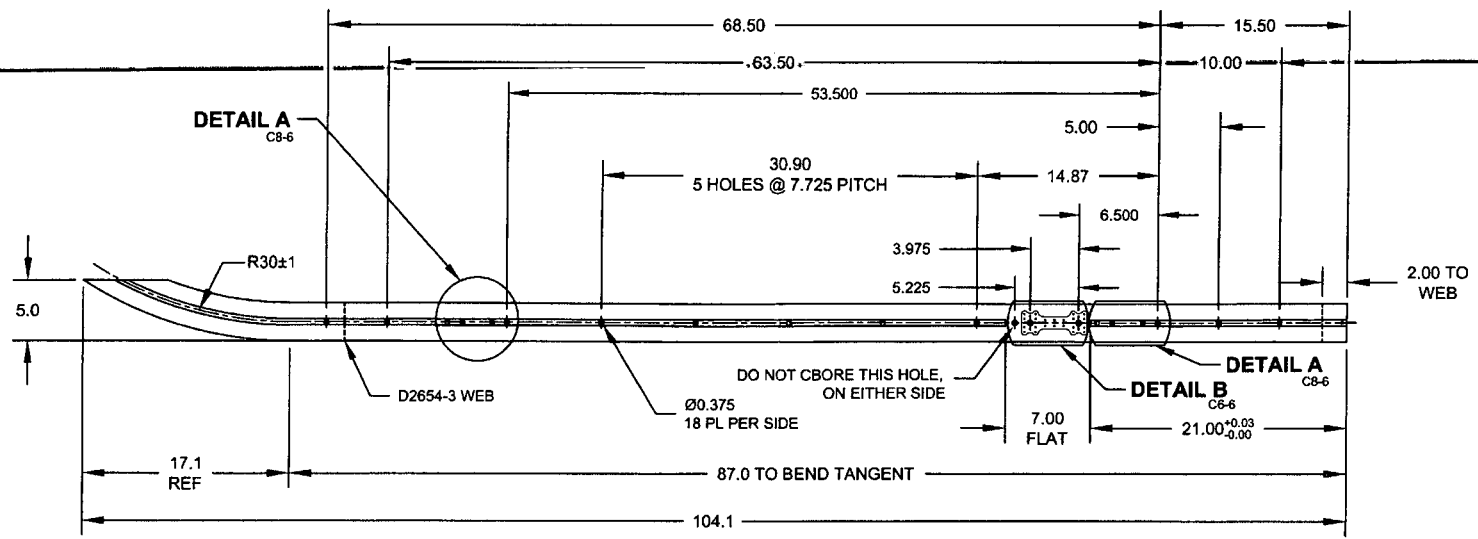
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

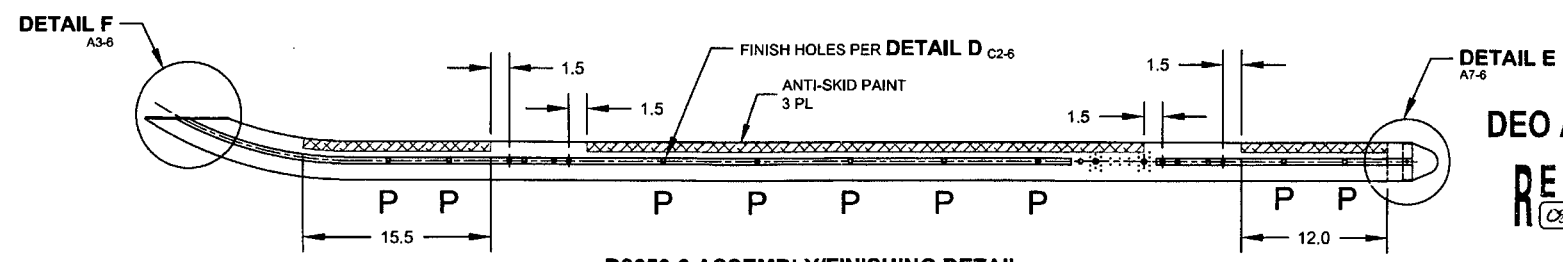
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *162242* *1705-30*

DEO ATTACHED
RELEASED
08-23-17

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



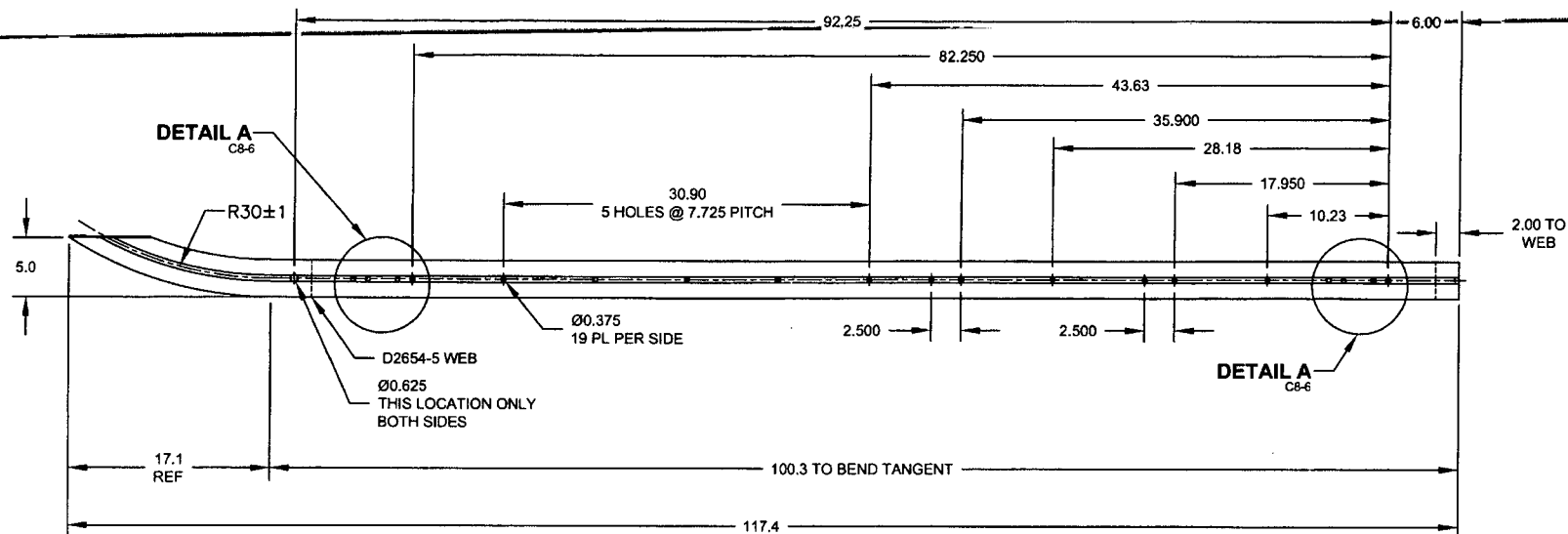
D2650-3 BENDING/DRILLING DETAIL



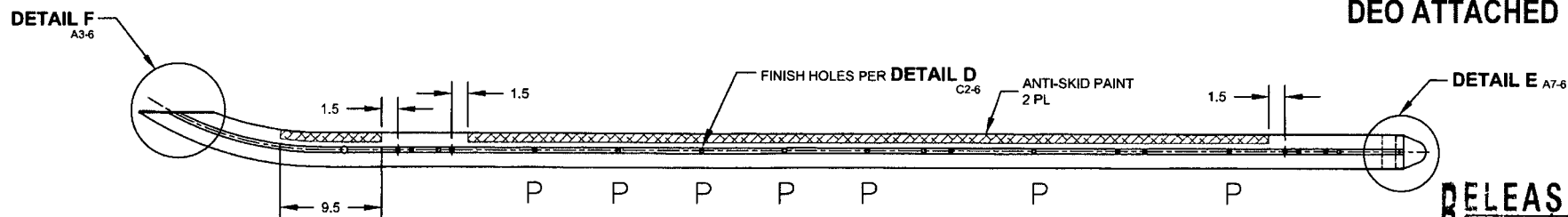
D2650-3 ASSEMBLY/FINISHING DETAIL

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RELEASED
08 07 22 118

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D2650-5 BENDING/DRILLING DETAIL

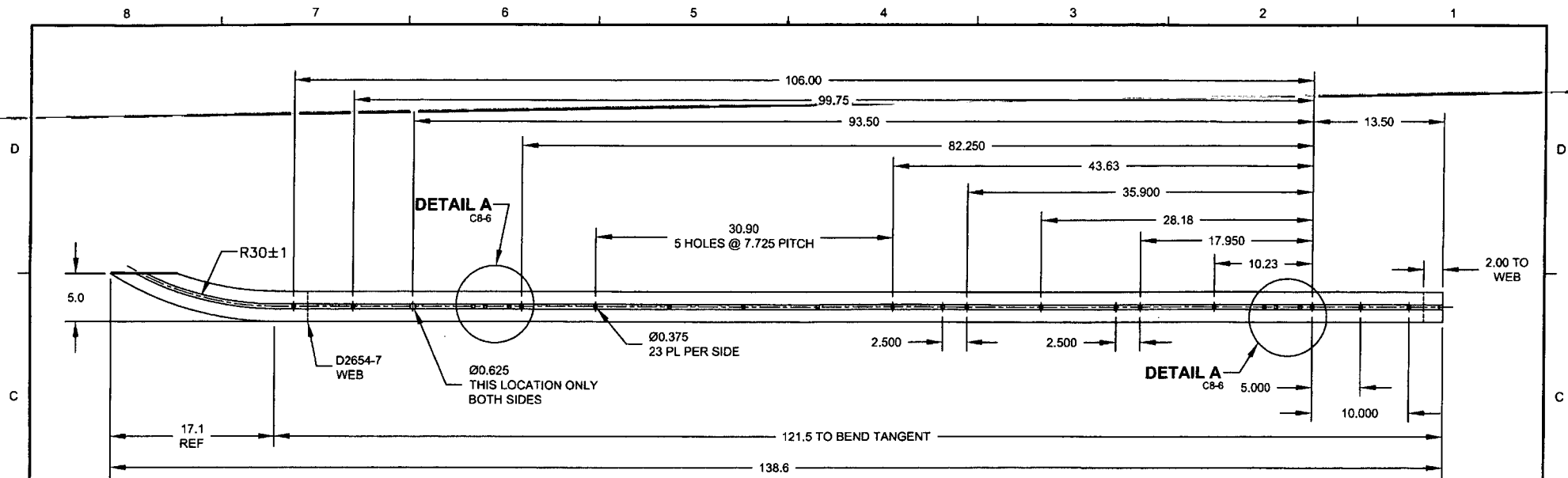


D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO. D2650	REV. F SHEET 4 OF 6
MFG. APPR.	E	TITLE	SCALE
APPROVED	AP	206/407 SKIDTUBE ASSEMBLIES	NTS
DE APPR.	H	DATE 08.08.08	

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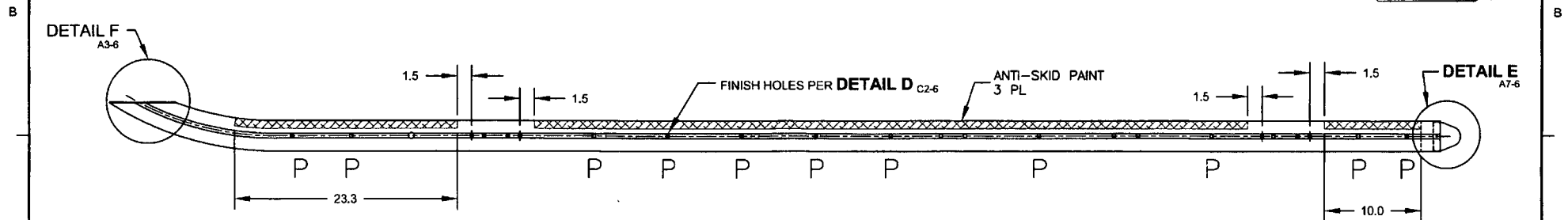
RELEASED
08.09.22/117



D2650-7 BENDING/DRILL DETAIL

DEO ATTACHED

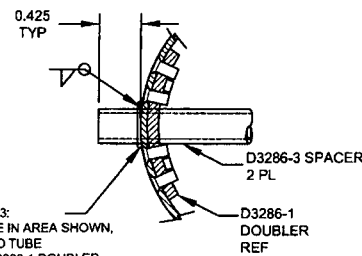
RELEASED
07-22



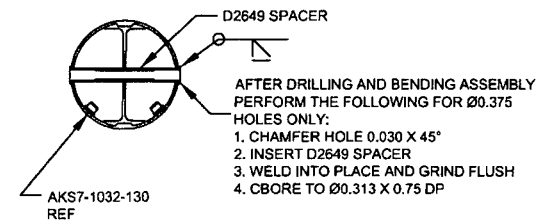
D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO. D2650	REV. F SHEET 5 OF 6
MFG. APPR.	B	TITLE	SCALE
APPROVED	H	206/407 SKIDTUBE ASSEMBLIES	NTS
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SECTION C-C C7-6
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5

DETAIL F NOTES:

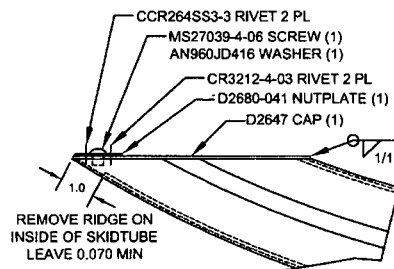
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-27-10
DEO ATTACHED

DETAIL F
SCALE NONE

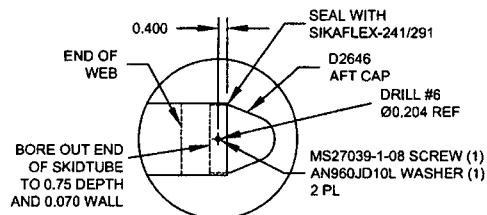
B8-2
B8-3
B8-4
B8-5



ORIENTATION OF
D2680-041

DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

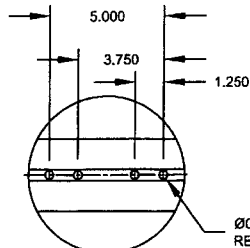
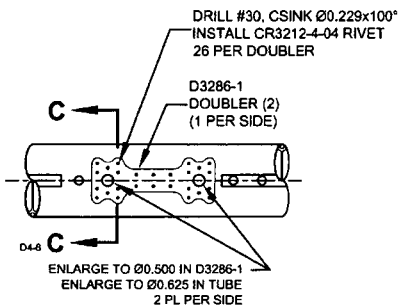


DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-5

DETAIL B
SCALE 2X

C3-2
C3-3



DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AP</i>	CHECKED <i>A.P.</i>	MFG. APPR. <i>AA</i>	APPROVED <i>TH</i>		DE APPR. <i>TH</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

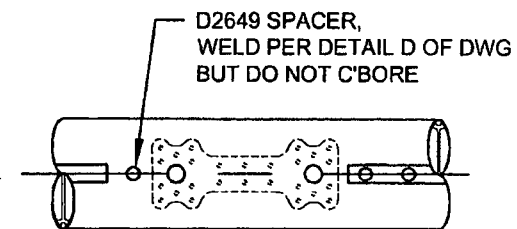
IS:

QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

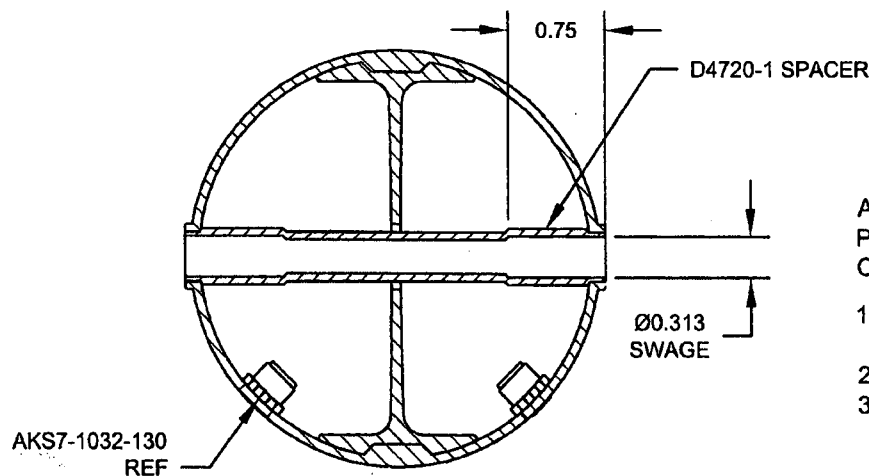
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
mp



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36936**

Purchase Order Date 7/5/2017

PO Print Date 7/7/2017

Page Number 5 of 5

Order From :

VC-ATE001

Ship To : DART AEROSPACE LTD

ATELIER DEBOSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

819 242 5633

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Line Total: **\$225.00**

13 162242

D206-642-341BL
Replacement Skidtube ✓

7/10/2017

1.00

\$225.00

\$225.00

Yes

Each

7/10/2017

8177-11

Line Total: **\$225.00**

PO Total: **\$3,138.00**

[Handwritten signatures]

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 5

Change Date: 7/7/2017



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on:

Monday, July 17, 2017

Details			
Raised Date 7/17/2017	Status Open	Owner Aboud, Robert	Number NCR17-6528
Target Date 7/19/2017	Standard		Severity
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) ATELIER DEBOSELAGE		Fault Category Supplier/Quality
Details the skidtube received from PO36936, had some various with the paint shade (some had a bit more of a shine rather than a matte finish). Also there two of them that had an extremely rough finish to it, which is not acceptable. Unfortunately four skid will need to be return and reworked by sanding the tube to a smooth finish and after repainting them. following batch to be return B162228, B162236, B162237, B162242.			
Keywords		Product D206-642-341bl	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 7/27/2017	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Corrective Action			
Target Date 7/27/2017	Owner Aboud, Robert	Closed Date	Closed By
Details			

Actions				
Number	Owner	Target Date	Completed Date	
Details		Response		
1	Aboud, Robert	7/19/2017		
return for rework. Skid will need to be scuff down smooth for all imperfection and re-finish.				
2	Duval, Patrick	7/19/2017		
visit supplier for root cause				

Implementing Corrective Action				
Target Date	Owner	Closed Date	Closed By	
7/27/2017				
Details				

Actions				
Number	Owner	Target Date	Completed Date	
Details		Response		

Verification & Review				
Target Date	Owner	Closed Date	Closed By	
	Downing, Eric M			
Details				

Actions				
Number	Owner	Target Date	Completed Date	
Details		Response		